

CLAIMS

What is claimed is:

- 5     1. A wipe comprising:
  - at least one non-woven web;
  - the web including an edge portion adjoining a main portion;
  - the web having a top surface and a spaced apart opposite bottom surface and defined by a width of the web which is perpendicular to a length of the web;
  - 10       the top surface of the main portion defining a top plane and the bottom surface of the main portion defining a bottom plane, where the top and bottom planes are parallel to one another and where a z-directional dimension of the web extends through the top and bottom planes and is orthogonal to the top and bottom planes; and,
  - 15       the edge portion including an edge treatment wherein the edge treatment comprises at least a portion of the edge portion being permanently deformed in a non-random pattern in the z-directional dimension such that the top surface of the edge portion defines a top edge plane and the bottom surface of the edge portion defines a bottom edge plane wherein at least one of the top edge plane and the bottom edge plane is outside of a bounded region defined between the top and bottom planes of the main portion.
- 20     2. A wipe comprising:
  - at least one non-woven web;
  - the web including an edge portion adjoining a main portion;
  - the web having a top surface and a spaced apart opposite bottom surface and defined by a width of the web which is perpendicular to a length of the web;
  - 25       the top surface of the main portion defining a top plane and the bottom surface of the main portion defining a bottom plane, where the top and bottom planes are parallel to one another and where a z-directional dimension of the web extends through the top and bottom planes and is orthogonal to the top and bottom planes; and,
  - 30       the edge portion including an edge treatment wherein the edge treatment comprises at least a portion of the edge portion being permanently deformed in a non-random pattern in the z-directional dimension whereby the edge portion has an Edge Resilient Value and the main portion has a Main Resilient Value such that the Edge Resilient Value is greater than the Main Resilient Value.
- 35     3. The wipe of claim 2 wherein the Edge Resilient Value is at least 10% greater than the Main Resilient Value.
4.     The wipe of claim 2 wherein the Edge Resilient Value is at least 20% greater than the Main Resilient Value.

5. The wipe of claim 2 wherein the Edge Resilient Value is at least 30% greater than the Main Resilient Value.
6. The wipe of claim 2 wherein the Edge Resilient Value is at least 50% greater than the Main Resilient Value.
- 5 7. A wipe comprising:
  - at least one non-woven web;
  - the web including an edge portion adjoining a main portion;
  - the web having a top surface and a spaced apart opposite bottom surface and defined by a width of the web which is perpendicular to a length of the web;
  - 10 the top surface of the main portion defining a top plane and the bottom surface of the main portion defining a bottom plane, where the top and bottom planes are parallel to one another and where a z-directional dimension of the web extends through the top and bottom planes and is orthogonal to the top and bottom planes; and,
  - 15 the edge portion including an edge treatment wherein the edge treatment comprises at least a portion of the edge portion being permanently deformed in a non-random pattern in the z-directional dimension whereby the edge portion has an Edge Length Value and the main portion has a Main Length Value such that the Edge Length Value is greater than the Main Length Value.
8. The wipe of claim 7 wherein the Edge Length Value is at least 5% greater than the Main Length Value.
- 20 9. The wipe of claim 7 wherein the Edge Length Value is at least 15% greater than the Main Length Value.
10. The wipe of claim 7 wherein the Edge Length Value is at least 25% greater than the Main Length Value.
- 25 11. The wipe of claims 1, 2 or 3 wherein the edge portion including the edge treatment is a leading edge of the wipe.
12. The wipe of claims 1, 2 or 3 wherein the wipe comprises a wet wipe.
13. A plurality of the wipes of claims 1, 2 or 3 wherein each wipe of the plurality of wipes is formed from a portion of a common material.
- 30 14. The wipe of claims 1, 2 or 3 wherein the non-woven web comprises a composite elastic material.
15. The wipe of claims 1, 2 or 3 wherein the edge treatment extends along substantially an entire length of the edge portion.
- 35 16. The wipe of claims 1, 2 or 3 wherein the wipe has at least a second edge portion distinct from the edge portion and the second edge portion includes the edge treatment along at least a portion of the second edge portion.
17. A plurality of the wipes of claims 1, 2 or 3 wherein each wipe is folded upon itself at

least once and each wipe is positioned relative to adjacent wipes to form a stack of wipes.

18. The plurality of wipes of claim 17 wherein the stack of wipes is configured in a reach-in format to dispense each wipe from a wipes dispenser.

19. The plurality of wipes of claim 17 wherein each wipe in the plurality of wipes is discrete from each adjacent wipe.

20. The plurality of wipes of claim 17 wherein each wipe is folded such that the edge portion is located between opposite sides of the wipe when the wipe is folded upon itself.

21. The wipe of claims 1, 2 or 3 wherein the wipe comprises a visual differentiation cue such that at least a bottom surface of the edge portion or a top surface of the edge portion is visually differentiated from the main portion of the wipe when the wipe is folded upon itself.

10 22. The wipe of claim 21 wherein the visual differentiation cue comprises at least the edge portion having a pattern or a color or both a pattern and a color applied to at least the leading edge portion and not applied to at least a portion of the main portion.

23. The wipe of claim 7 wherein the Length Value is determined in the CD of the wipe 15 and the Edge Length Value is at least 5% greater than the Main Length Value.

24. The wipe of claim 7 wherein the Length Value is determined in the CD of the wipe and the Edge Length Value is at least 10% greater than the Main Length Value.

25. A process for forming the wipes of claims 1, 2 or 3 into a stack of wipes comprising:

(a) providing a supply of a common material;

20 (b) forming a plurality of panels, each panel adjacent to at least one other panel;

(c) creating the edge treatment located along at least one side of each panel;

(d) converting the plurality of panels into a plurality of wipes, each wipe of the plurality of wipes including a leading edge portion with the edge treatment located along at least a portion of the leading edge portion and the edge treatment being distinct from an adjoining main portion of each wipe; and

25 (e) positioning each wipe relative to adjacent wipes to form the stack of wipes.

26. The process of claim 25 wherein converting comprises folding at least once each wipe of the plurality of wipes.

27. The process of claim 25 wherein creating comprises creating the edge treatment in a 30 machine direction of the plurality of panels.

28. The process of claim 25 wherein converting comprises wetting the plurality of panels to form a stack of wet wipes.

29. The process of claim 25 wherein forming comprises separating the panels from one another intermediate the edge treatment so as to create the edge treatment along each side 35 of the panels.